

Work Order ID 59200 - 1

Friday, May 28, 2010 9:17:21 AM



Page 1

Item ID: K10003

Accept



Setup Start



Revision ID:

Item Name: Saddle, D205-634-011

Stop



Start Date: 5/27/2010 Start Qty: 10.00

Required Date: 6/4/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-21 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN634,635

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels only per PPP K10003

CHG 007

8.10.15/31

10-5-31 BG 10/05/28

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10-5-31 @ SP

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8.10.15/31

46

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: DK

0.00

Ren 210-5-21WD SP

Memo

0.00

Packaging

140



QC

QC21- Final Inspection - Work Order Release

0.00

10/06/02

Memo

0.00

Quality Control

R/10-6-01
(6)

W/O:		WORK ORDER CHANGES						
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Page 1

Work Order ID: 59200

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 10.00

Required Qty: 10.00

AN4-51A



Bolt

Purchased No

110 Each

136.0000

8 80



10-5-31 SP

Location

Loc Qty

Loc Code

ST361

136

112720

2

113121

34

114437

15

114495

85

33
13

AN4-6A



Bolt

Purchased No

110 Each

886.0000

16 160



10-5-31 SP

Location

Loc Qty

Loc Code

ST356

886

112933

96

113149

600

114523

2

114615

188

96

AN4C47A



Bolt

Purchased No

110 Each

77.0000

4 40



10-5-31 SP

60

Location

Loc Qty

Loc Code

ST361

77

114653

77

24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 10.00

Required Qty: 10.00

AN6-12A

Purchased No

110 Each

166.0000

8 80



Bolt

Location

Loc Qty

Loc Code

ST342

166

112314

66

114523

100

48

AN960JD416

NAS1149D0463J

Purchased No

110 Each

0.0000

32 320



Washer

M114576

10-5-31

AN960JD616

NAS1149D0663J

Purchased No

110 Each

0.0000

8 80



Washer

M113584

10-5-31

D2570

Manufactured No

110 Each

238.0000

24 240



Bushing

10-5-31

10-5-31

Location

Loc Qty

Loc Code

ST018

238

57509

38

58177

200

38

100

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 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 10.00

Required Qty: 10.00

D2571



Saddle, Fwd Out 205

Manufactured No

110 Each

19.0000

1 10



10-5-31

sl

Location

Loc Qty

Loc Code

ST425

8

43564

4

47564

4

ST433

11

58250

3

58667

8

3
63

D2572



Saddle, Fwd In 205

Manufactured No

110 Each

13.0000

1 10



10-5-31

sl

Location

Loc Qty

Loc Code

ST425

4

43565

4

ST433

9

58100

1

58668

8

1
8

D2573



Saddle, Aft Out 205

Manufactured No

110 Each

16.0000

1 10



10-5-31

sl (C)

Location

Loc Qty

Loc Code

ST425

8

43566

4

47566

4

ST434

8

58251

8

8

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 10.00

Required Qty: 10.00

D2574



Saddle, Aft In 205

Manufactured No

110 Each

12.0000



10

10-5-31 sl

Location

Loc Qty

Loc Code

ST425

4

43567

4

ST434

8

58252

8

Manufactured No

110 Each

105.0000



40

10-5-31

sl

D2747



Set Screw

Location

Loc Qty

Loc Code

ST023

105

39224

4

51921

101

Manufactured No

110 Each

89.0000



20

24

10-5-31

sl

D2876



Saddle Spacer

Location

Loc Qty

Loc Code

ST028

89

42364

42

51540

47

Manufactured No

110 Each

84.0000



20

12

10-5-31

sl

pc

D2877



Saddle Spacer

Location

Loc Qty

Loc Code

ST028

84

51541

21

58531

63

12

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP: J 06-07-25 As per DSI 9344 JLM
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 IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 10.00

Required Qty: 10.00

D3405-041



Lug Assembly

Manufactured No

110 Each

14.0000

1 10



10-5-31

Location

Loc Qty

Loc Code

ST474

14

56835

2

57726

12

D3405-043



Lug Assembly

Manufactured No

110 Each

16.0000

1 10



10-5-31

Location

Loc Qty

Loc Code

ST474

16

53888

1

56574

1

57727

14

D3407-041



Tow Ring

Manufactured No

110 Each

13.0000

1 10



10-5-31

Location

Loc Qty

Loc Code

ST464

13

58209

13

D3417-5



Washer

Manufactured No

110 Each

45.0000

2 20



10-5-31

(40)

Location

Loc Qty

Loc Code

ST056

45

52344

45

6

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 IPP : J 06-07-25 As per DSI 9344 JLM
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 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 10.00

Required Qty: 10.00

D3456-1



Washer

Manufactured No

110 Each

129.0000

1 10



10-5-31

sl

Location

ST058

Loc Qty

129

Loc Code

54692

129

110 Each

119.0000

2 20



10-5-31

sl

D3533-1



Set Screw

Manufactured No

Location

ST069

Loc Qty

119

Loc Code

51602

119

110 Each

4,601.000

24 240



10-5-31

sl

44

MS21042L4



Nut

Purchased No

Location

ST139

Loc Qty

2

Loc Code

111827

2

ST300

4599

113422

76

114523

1515

114718

1000

114784

2000

9063

8

3
141

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 10.00

Required Qty: 10.00

MS21043-4

Purchased No

110 Each

1,628.000

5 50



Nut



10-5-31

6x5

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST301	1588	
112492	25	
113069	8	
114181	255	
114348	500	
114523	500	
114784	300	

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07

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